

Work Order ID 111307

January-10-14 11:42:15 AM

111307

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-01-10 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2750-042	G
-----------	---

D3492	C
-------	---

M.I.

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

record fwd angle: 89.3°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DP 14-1-30

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop *NS2*

Start Date: 1/10/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/24/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail J to 0.297" (total of 2 holes per side)

14-1-30

4

January-10-14 11:42:15 AM

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

12-Grind welds flush as per Dwg D2750

Quality Control

QC	Memo	0.00
----	------	------

Quality Control

① 14-01-31

① 14-0131

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Quality Control

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Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 127918
exp. date: 1-8-16

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: m127069

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

14-2-3 DGL

mm 14-0210

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Item ID: D350-636-012

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N900040100

Setup Start

NS1

Revision ID:

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NS2

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Start Date: 1/10/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/24/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

dwg D2750

12-Deburr holes

mm

14-02-10

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

① 14-02-10

DAS
9
9-89

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

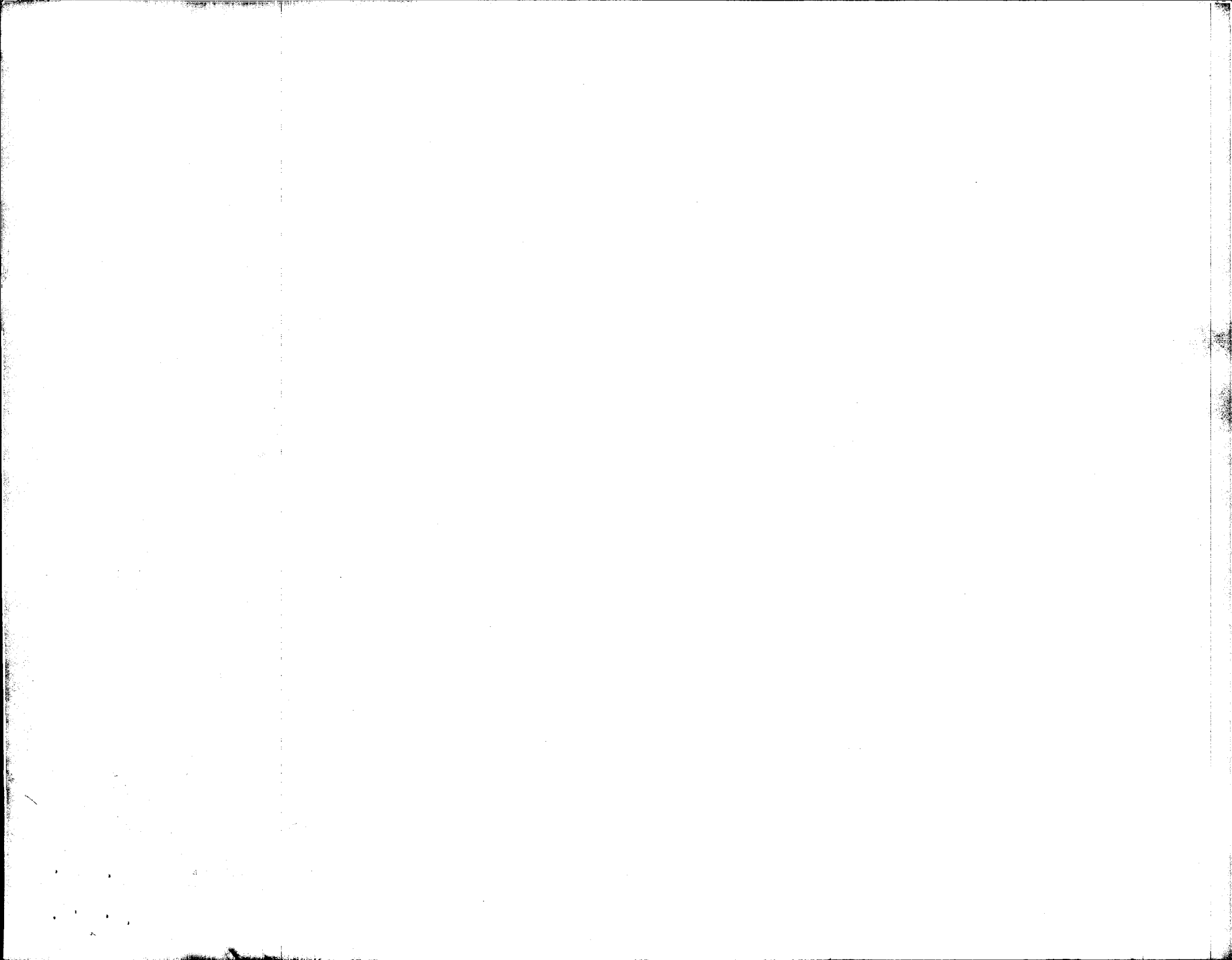
0.00

Quality Control

VERIFY C'BOARD IS GOOD

① 14-02-10

DAS
9
9-89



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Item ID: D350-636-012

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	76	14-2-14	
190	HandFinish	0.00							
Hand Finishing	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00				1			
200	SprayPaint	0.00							CR/AS
Spray Painting	Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>126 543</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>M 128 178</u>							14-2-24	
210	QC14- Inspect Spray Paint	0.00				1			
210	QC	0.00							M/A 14-02-25
Quality Control	Memo Inspect for foreign object per QSI 024								

~~STOP AT THIS OPERATION
DO NOT ASSEMBLE TUBE!~~

OK to
Assemble
see next pg.

Linda Lacelle

From: David Shepherd
Sent: January-16-14 2:23 AM
To: Linda Lacelle
Cc: Nigel Forbes
Subject: RE: Received Approval for 350 PMA Replacement Skidtubes

Agreed ... I would paint and then stop ... for now.

Regards,
David

-----Original Message-----

From: Linda Lacelle
Sent: January-15-14 12:36 PM
To: David Shepherd
Cc: Nigel Forbes
Subject: FW: Received Approval for 350 PMA Replacement Skidtubes

Hi David,

I have removed the w/o's from the shop floor and was going to mark them up to stop at a certain point. Nigel and I are guessing after paint (no ass'y), but I'm worried that this will change. Can you confirm we can paint and stop there...i just have a funny feeling.

L

-----Original Message-----

From: Nigel Forbes
Sent: January-14-14 9:52 AM
To: Linda Lacelle
Subject: FW: Received Approval for 350 PMA Replacement Skidtubes

FYI

-----Original Message-----

From: Bill Beckett
Sent: January-14-14 9:07 AM
To: Nigel Forbes; David Shepherd

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>11177918</u> EXP DATE: <u>1/10/8</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>11177651</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>11122960</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

DO NOT
ASSEMBLE
11/10/02-27

134 11 11/02/27

1 11/14/03

Work Order ID 111307

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111307

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Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____


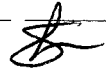
Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				1x	DAS 28 9-89	14-03-4	
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00	DAS 31 9-89	14-03-05					
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00				1	DAS 6 9-89		
Packaging	Package as per PPP D350-636-012								MAR 05 2014 

Work Order ID 111307

January-10-14 11:42:15 AM

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop *NS2*

Start Date: 1/10/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

280

QC Memo

0.00

Quality Control

11403-5

January-10-14 11:42:19 AM

111307

D350-636-012

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
AS PER REV F JLM 13-08-22 VERIFIED BY:DD
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	3.0000	1	1			
D2600-3-BFNT Extrusion Bent													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002	110478	3							
					109789	3							
D2744		Manufactured	No			110	Each	49.0000	1	1			
D2744 Cap													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		49							
					100398	28							
					87543	21							
D2739		Manufactured	No			160	Each	5.0000	1	1			
D2739 350 I Beam													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002	110835	5							
					109973	5							

Picklist Print

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Work Order ID: 111307

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 299.0000 8 8

D2743

Crossbolt Spacer

BE14-02-04

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	299	
106245	9	
107359	36	
107907	122	
109799	132	

D3490-3 Manufactured No 160 Each 144.0000 4 4

D3490-3

Cross Bolt Spacer

BE14-02-04

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	144	
103883	1	
107913	63	
109933	80	

D3490-1 Manufactured No 160 Each 209.0000 4 4

D3490-1

Cross Bolt Spacer

BE14-02-04

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	209	
107419	41	
109932	168	

D3631-1 Manufactured No 230 Each 112.0000 8 8

D3631-1

Washer

all 1/10/27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	112	
107324	12	
110258	100	

B111546

VE

January-10-14 11:42:19 AM

Shop Packet Print

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Picklist Print

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Page 3

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111307

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D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

15.0000

1

1

D3791-1

Wearpad

**

ll 1/10/14

Location

Loc Qty

Loc Code

FP002

15

B110712

106144

3

109511

12

D3793-3

Manufactured No

230

Each

11.0000

1

1

D3793-3

Wearplate Aft

**

ll 1/10/14

Location

Loc Qty

Loc Code

FP001

11

3110066

104212

11

MS21043-6

Purchased No

230

Each

518.0000

4

4

MS21043-6

NUT

**

ll 1/10/14

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

248

m127255

248

ST509

250

m127813

250

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

25.0000

1

1

D3794-1

Gasket Fwd

**

11/02/27

Location

Loc Qty

Loc Code

FP001

25

104620

1

108497

5

109207

7

110316

12

✓1

NAS1611-010

Purchased No

230

Each

195.0000

8

8

NAS1611-010

O-RING

**

11/02/27

Location

Loc Qty

Loc Code

FP001

195

m126988

45

m127813

150

✓8

D2741

Manufactured No

250

Each

39.0000

1

1

D2741

Blade

**

DAS
28
9-88

14-03-4

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

28

107206

28

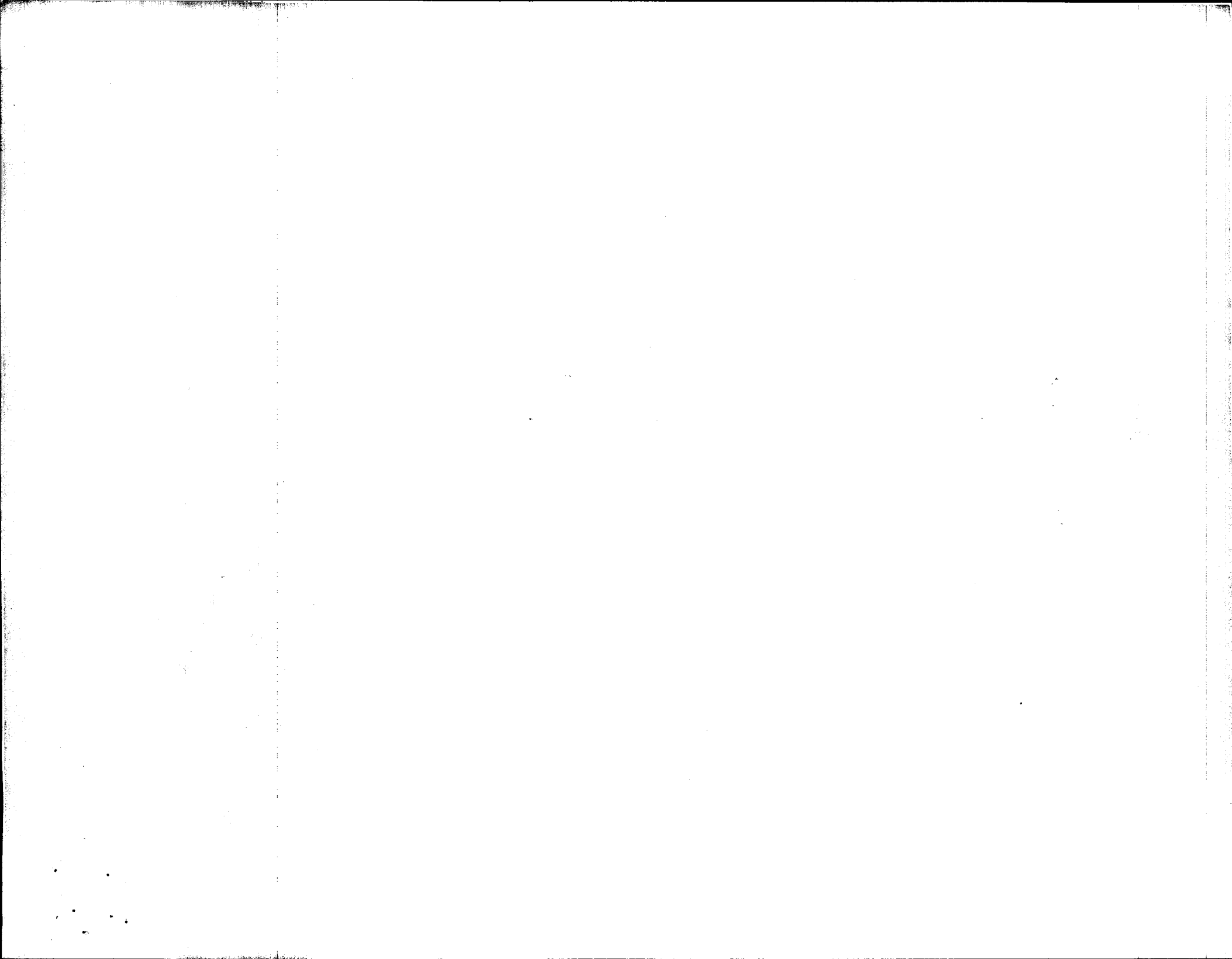
110710

DAS
31
9-89

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Picklist Print

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

454.0000

4

4

***NAS1515H3I ***

Washer

**

ell 1/10/2/27

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

414

124542

14

m127831

400

✓

NAS1611-013

Purchased

No

230

Each

166.0000

8

8

NAS1611-013

O-RING

**

ell 1/10/3/08

Location

Loc Qty

Loc Code

FP001

166

125445

16

m127813

150

M128378

✓

AN3C6A

Purchased

No

230

Each

535.0000

4

4

AN3C6A

Bolt

**

ell 1/10/2/27

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

525

m125709

525

✓

Picklist Print

January-10-14 11:42:19 AM

Work Order ID: 111307

111307

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

359.0000

1

1

NAS1149C0832R

Washer

**

ll 1/10/2/27

Location

Loc Qty

Loc Code

ST292

359

122441

92

m114915

117

m125807

150

✓

D3536-25

Manufactured

No

230

Each

19.0000

1

1

D3536-25

Gasket Center

**

ll 1/10/2/27

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

13

109206

13

B113008

x1

D3794-3

Manufactured

No

230

Each

17.0000

1

1

D3794-3

Gasket Aft

**

ll 1/10/2/27

Location

Loc Qty

Loc Code

FP001

17

108413

17

B110910

✓

AN3C5A

Purchased

No

230

Each

113.0000

34

34

AN3C5A

Bolt

**

ll 1/10/2/27

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

108

m127290

108

M128057

x34

Picklist Print

January-10-14 11:42:19 AM

Page 7

Work Order ID: 111307

111307

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

45.0000

3

3

D3537-1

Wearpad

14/02/27

Location

Loc Qty

Loc Code

FG

18

79833

8

B111594

x3

88562

10

FP001

27

109600

27

D3535-25

Manufactured No

230

Each

13.0000

1

1

D3535-25

Wearplate Center

14/02/27

Location

Loc Qty

Loc Code

FG

2

95077

2

B110744

x1

FP002

11

106128

11

D3492-3

Manufactured No

230

Each

277.0000

8

8

D3492-3

Plug

14/02/27

Location

Loc Qty

Loc Code

FP001

277

104853

72

107331

105

109800

100

x0

Picklist Print

January-10-14 11:42:19 AM

Work Order ID: 111307

111307

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

11,562.00

38

38

NAS1149C0332R

**

WASHER

Location

Loc Qty

Loc Code

GA

1233

125654

1233

st510

10329

m126319

2429

m127306

2500

m127410

3000

m127831

2400

x38

D3488-042

Manufactured

No

230

Each

19.0000

1

1

D3488-042

**

Blade Fitting RH

Location

Loc Qty

Loc Code

FP001

19

106658

6

109134

10

98887

3

B109134

x1

ALS4-1032-225

Purchased

No

230

Each

380.0000

38

38

ALS4-1032-225

**

Rivnut

Location

Loc Qty

Loc Code

FG

30

M127028

30

ST280

10

M127028

10

st555

340

M127092

340

M1128179

x38

Picklist Print

January-10-14 11:42:19 AM

Page 9

Work Order ID: 111307

111307

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

195.0000

8

8

D3492-1

Plug

**

ll 11/02/27

Location

Loc Qty

Loc Code

FP001

195

104844

195

VB

D3793-1

Manufactured No

230

Each

6.0000

1

1

D3793-1

Wearplate Fwd

**

ll 11/02/27

Location

Loc Qty

Loc Code

FP002

6

109205

6

B111467

VI

AN8C35A

Purchased No

230

Each

125.0000

1

1

AN8C35A

Bolt

**

ll 11/02/27

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

121

m126293

47

m127061

24

m127823

50

VI

MS21083C8

Purchased No

230

Each

85.0000

1

1

MS21083C8

Nut

**

ll 11/02/27

Location

Loc Qty

Loc Code

ST319

85

m127255

35

m127813

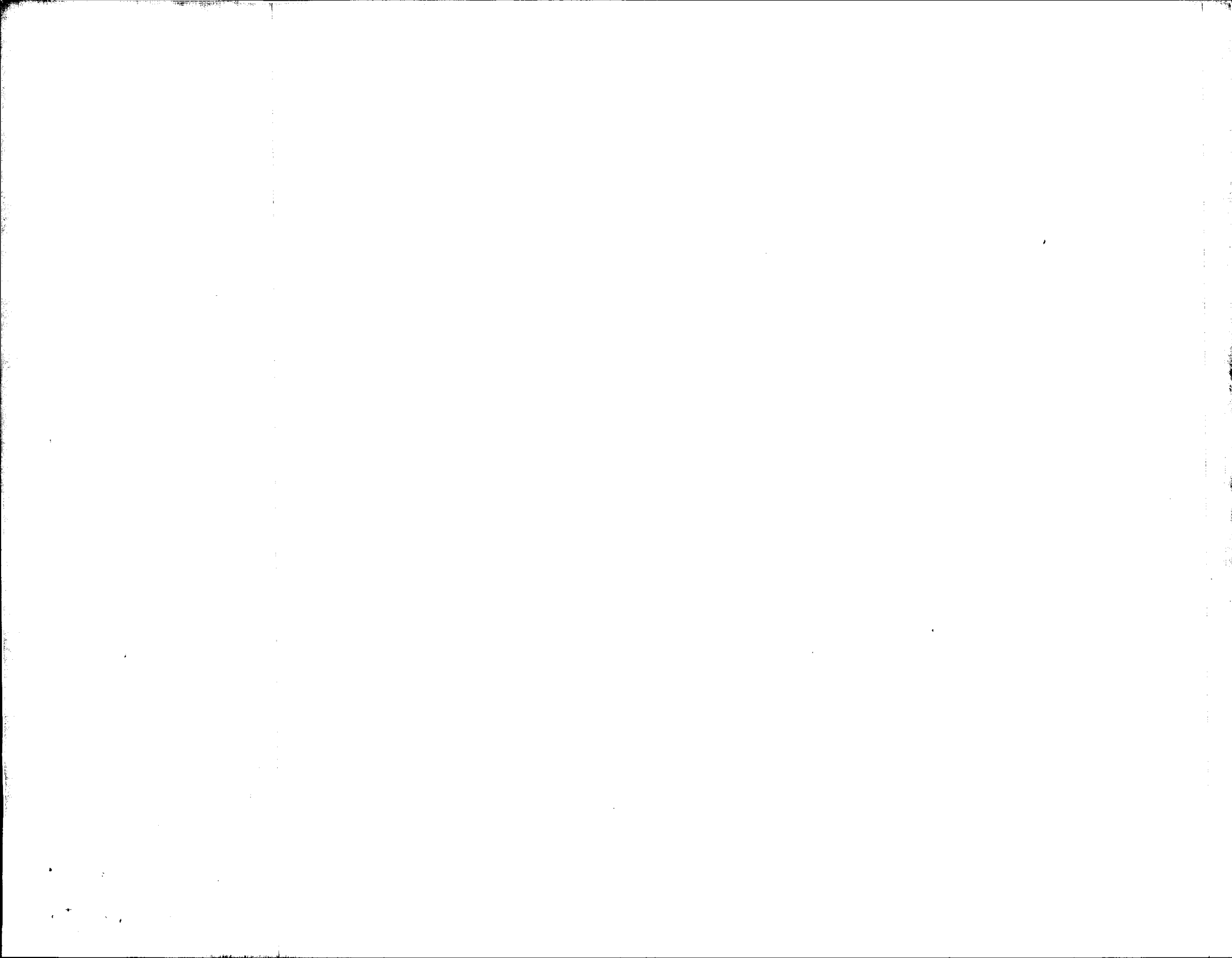
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VI

January-10-14 11:42:19 AM

Shop Packet Print

Page 9



Picklist Print

January-10-14 11:42:19 AM

Work Order ID: 111307

111307

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

229.0000

8

8

D2745

Bushing

**

Handwritten signature

Location

Loc Qty

Loc Code

ST017

229

106847

5

107336

124

110526

100

Handwritten marks

AN6C44A

Purchased No

230

Each

56.0000

4

4

AN6C44A

Bolt

**

Handwritten signature

Location

Loc Qty

Loc Code

FG

2

103964

2

ST340

50

123900

50

ST341

4

m127300

4

Handwritten: M128319

Handwritten marks

D3532-1

Manufactured No

250

Each

86.0000

2

2

D3532-1

Spacer

**

DAS
28
9-89



Handwritten: 14-03-4

Location

Loc Qty

Loc Code

ST054

86

100519

26

109803

60

Handwritten: 2x

DAS
31
9-89

Picklist Print

Page 11

January-10-14 11:42:19 AM

Work Order ID: 111307

111307

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

85.0000

2

2

MS21083C8

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

ST319

85

m127255

35

m127813

50

128119

DAS
28
9-89

14-03-4

NAS1149D0863J

Purchased

No

250

Each

991.0000

2

2

NAS1149D0863J

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

6

118078

6

ST293

185

125484

185

ST510a

800

125268

600

125635

200

2x

DAS
28
9-89

D3493-1

Manufactured

No

250

Each

245.0000

2

2

D3493-1

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

235

105613

16

107916

60

109105

159

2x

DAS
28
9-89

DAS
28
9-89

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

January-10-14 11:42:19 AM

Shop Packet Print

Page 11

Picklist Print

Page 12

January-10-14 11:42:19 AM

Work Order ID: 111307

111307

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

95.0000

2 2

AN8C21A

Bolt

**

DAS
28
9-89

14-03-4

DAS
31
9-89

Location

Loc Qty

Loc Code

ST

2

123966

2

st339

43

m127061

43

ST508

50

m127823

50

128319

January-10-14 11:42:19 AM

Shop Packet Print

Page 12

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

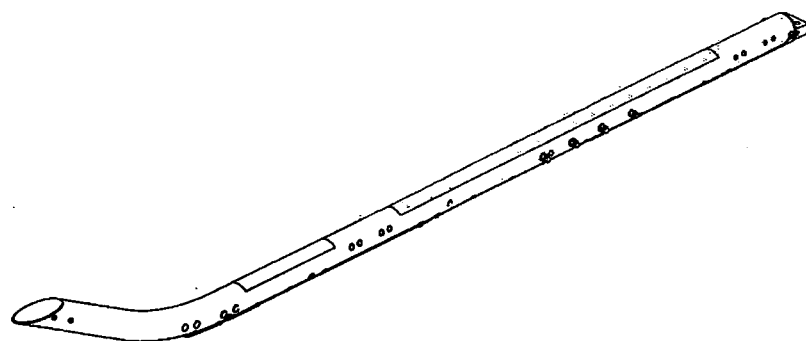
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

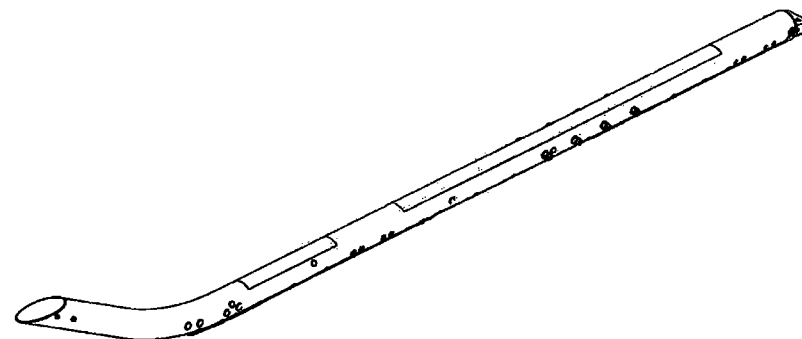
111307 MJS
14-01-10

RELEASED
2013-08-13
ND

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2739 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	B	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JP	D2750	SHEET 1 OF 11
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT AND ITS CONTENTS ARE SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

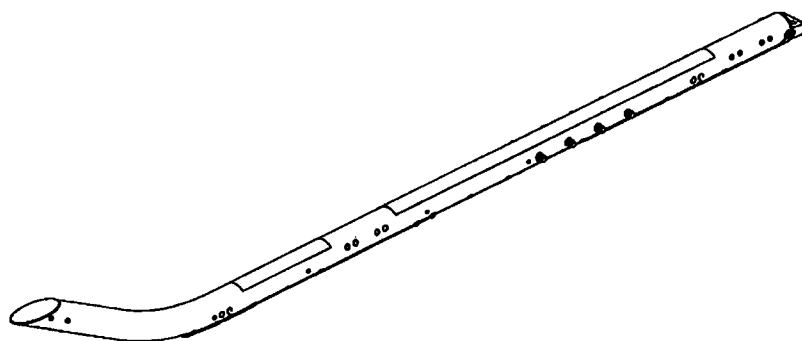
RELEASED
2013-08-13
MD

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS APPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

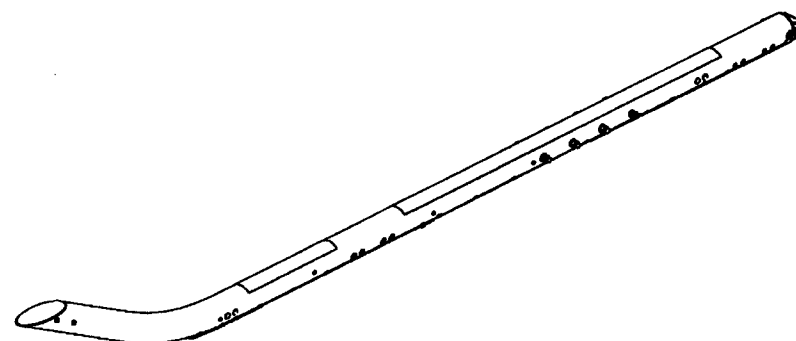
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
WDP

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

8

7

6

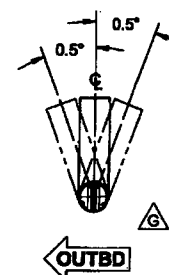
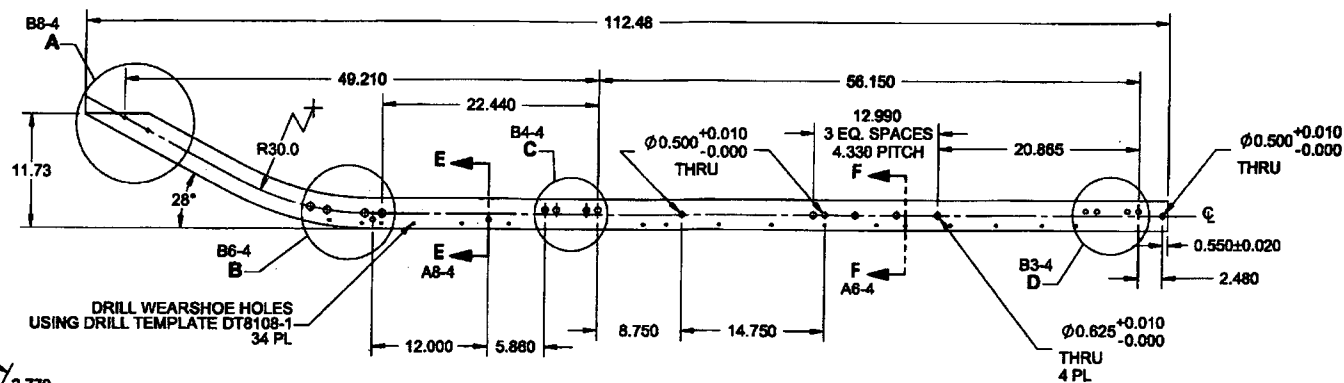
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4

3

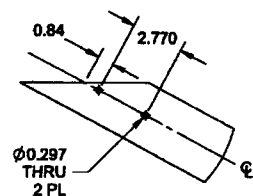
2

1

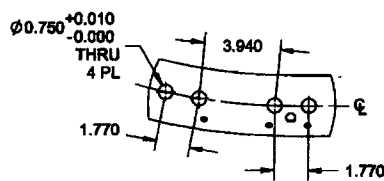


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

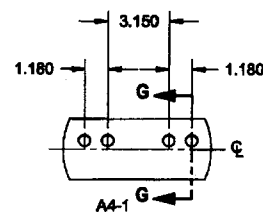
D2750-1 LH SKIDTUBE



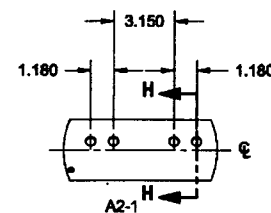
DETAIL A
SCALE 2X



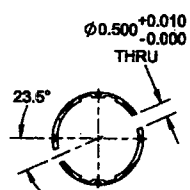
DETAIL B
SCALE 2X



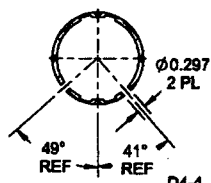
DETAIL C
SCALE 2X



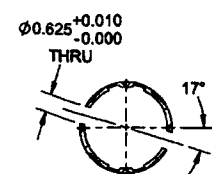
DETAIL D
SCALE 2X



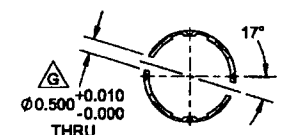
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



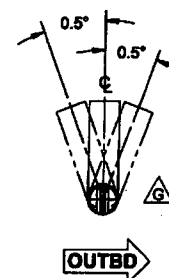
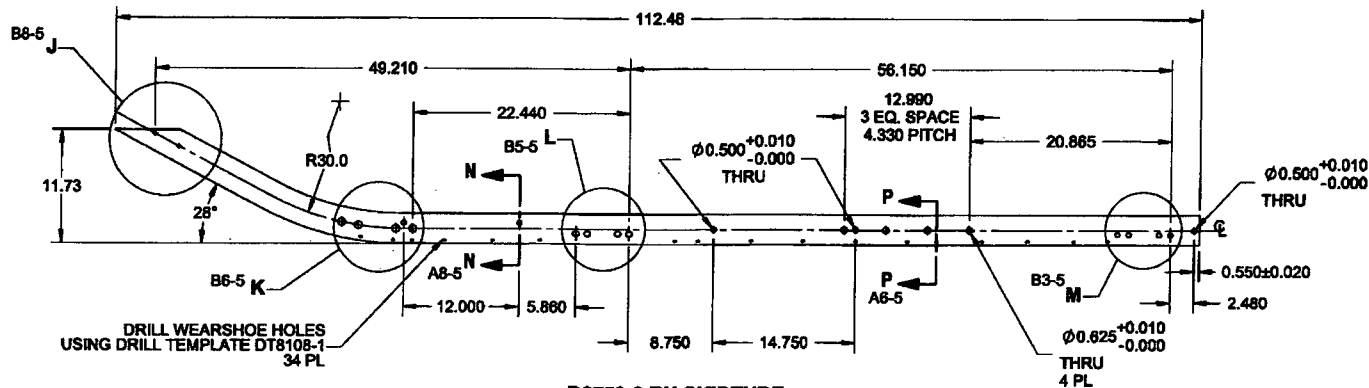
SECTION G-G
SCALE 3X, 4 PL



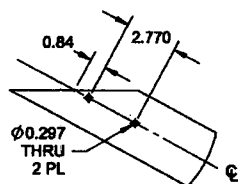
SECTION H-H
SCALE 3X, 4 PL

RELEASED
2013-08-13

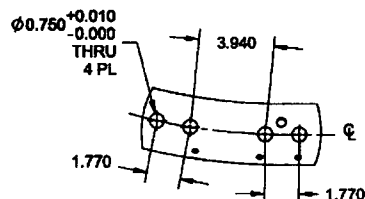
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PREPARED AND CONTROLLED BY DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



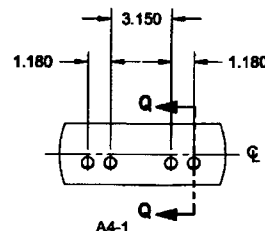
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



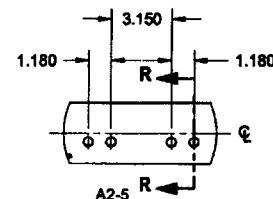
DETAIL J
SCALE 2X



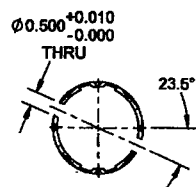
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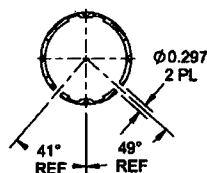
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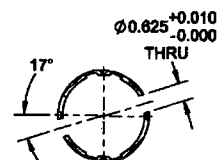
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SCALE 2X



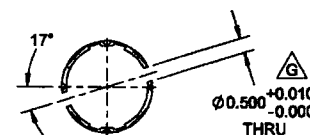
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



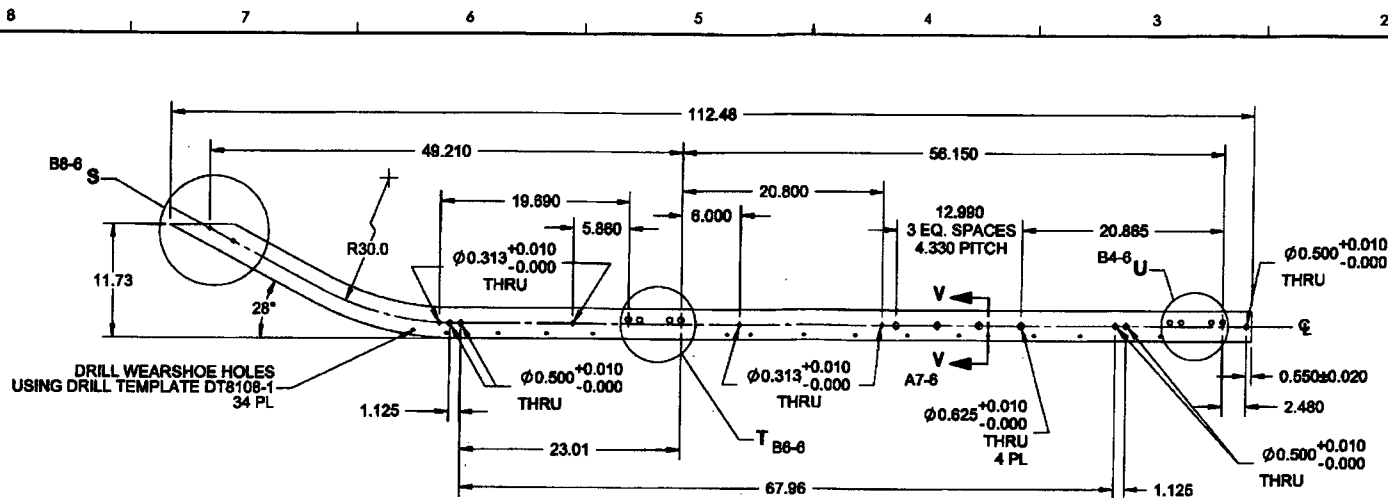
SECTION Q-Q
SCALE 3X, 4 PL



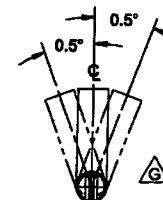
SECTION R-R
SCALE 3X, 4 PL

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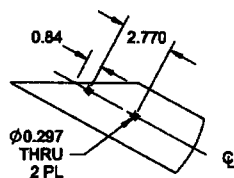
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2013-08-13



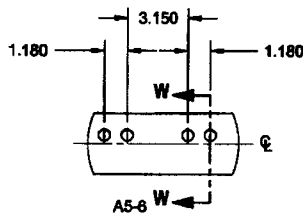
D2750-3 LH SKIDTUBE



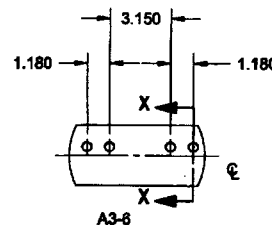
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



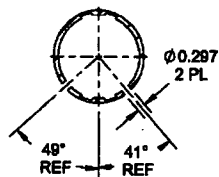
DETAIL S
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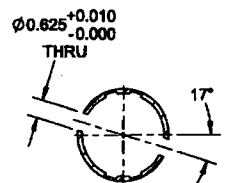
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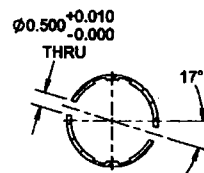
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



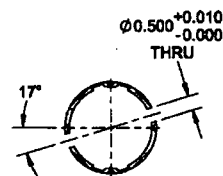
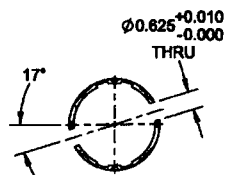
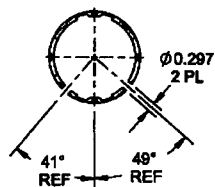
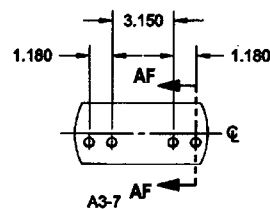
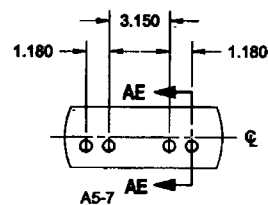
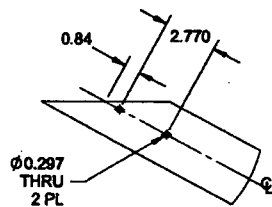
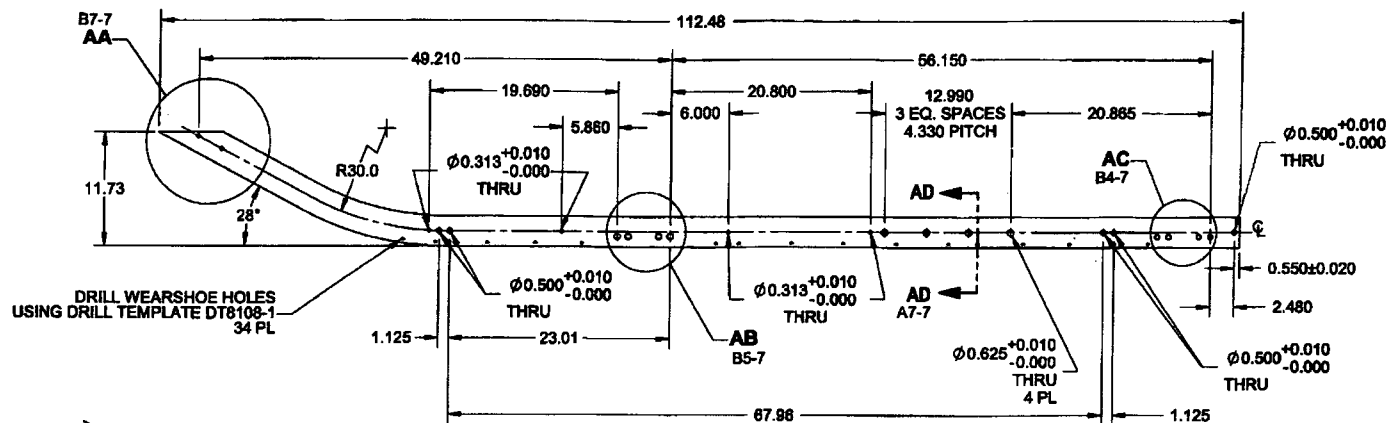
SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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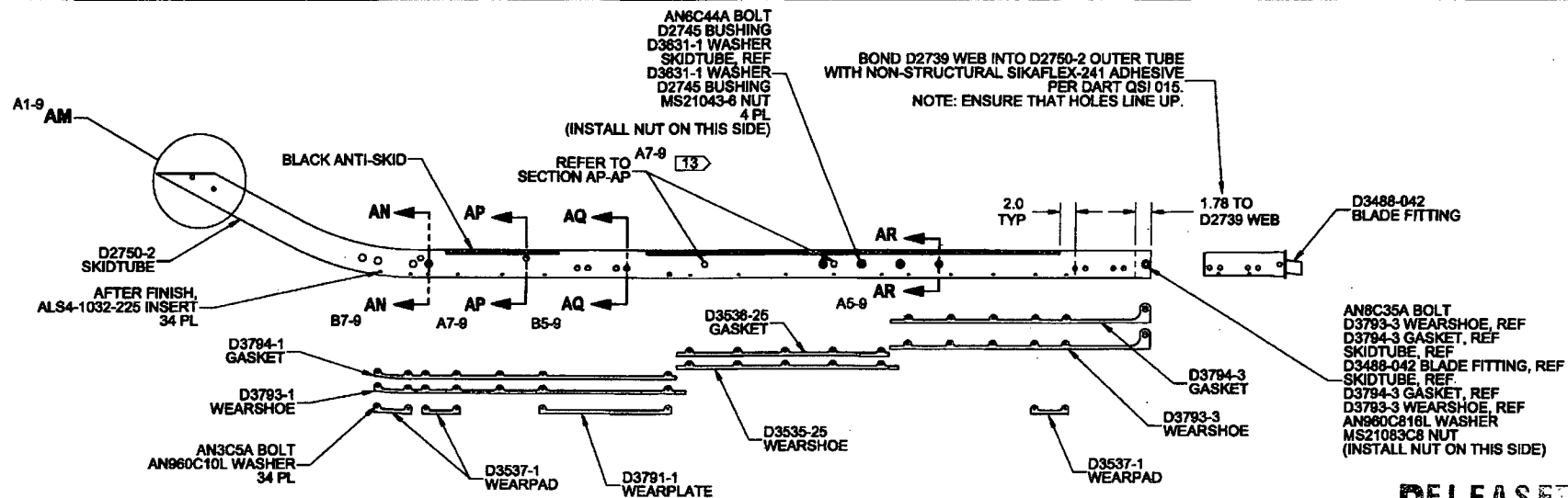
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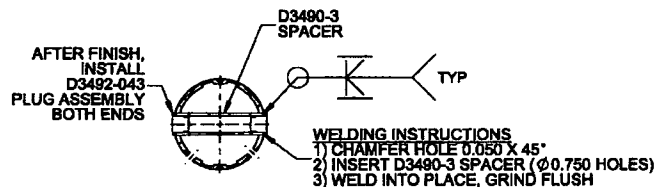
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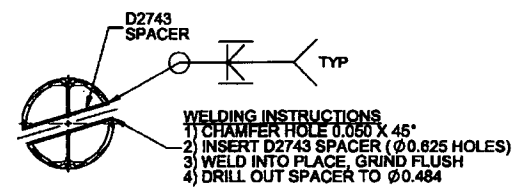


D2750-042 350 SKIDTUBE ASSEMBLY, RH

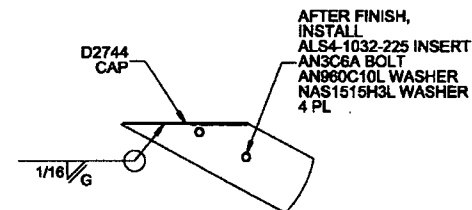
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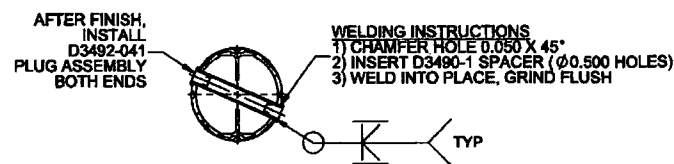
SECTION AN-AN
SCALE 3X, 4 PL



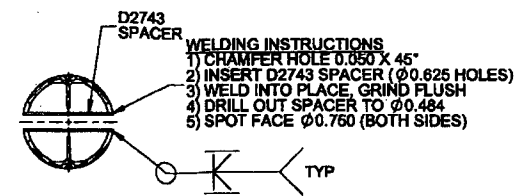
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X

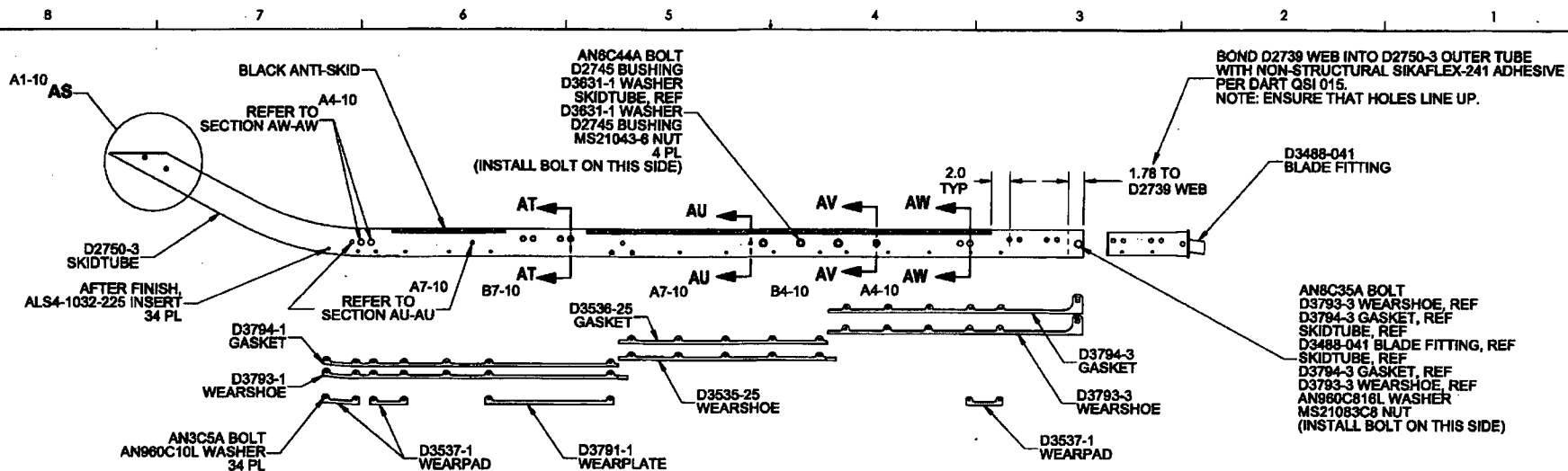


SECTION AP-AP
SCALE 3X, 4 PL



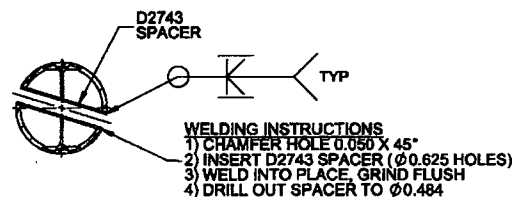
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

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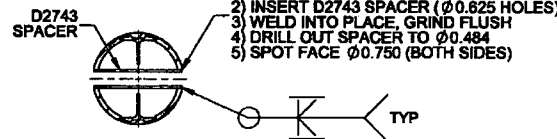


D2750-043 350 SKIDTUBE ASSEMBLY, LH

RELEASE
2013-08-13

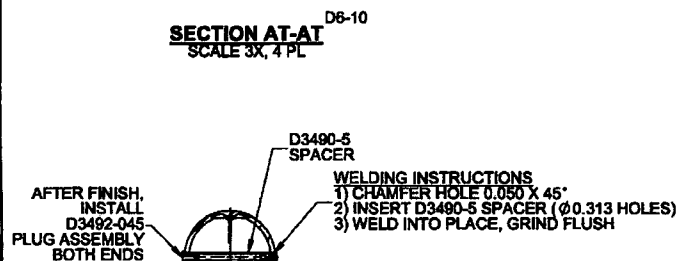


SECTION AT-AT SCALE 3X, 4 PL

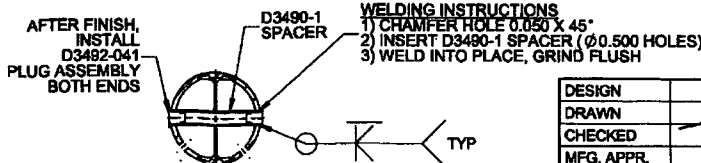


SECTION AV-AV SCALE 3X, 4 PL

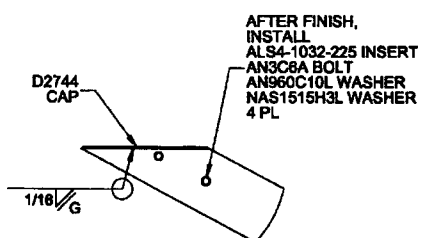
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SECTION AU-AU SCALE 3X, 4 PL



SECTION AW-AW SCALE 3X, 4 PL



DETAIL AS SCALE 2X

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No. 337

**AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD**

Name: Barclay Elliott
Job #: B110477
Part #: D350-636-012
Description: 350 skid tube
Welding Process: TIG [☒] MIG []
Base Material: Aluminium
Current: AC [☒] DC []

TEST REQUIREMENTS AND RESULTS

Visual:	pass [<input checked="" type="checkbox"/>] fail []
Penetration:	pass [<input checked="" type="checkbox"/>] fail []
Fusion:	pass [<input checked="" type="checkbox"/>] fail []
Cracks:	pass [<input checked="" type="checkbox"/>] fail []
Overlap (cold lap)	pass [<input checked="" type="checkbox"/>] fail []
Undercut:	pass [<input checked="" type="checkbox"/>] fail []
Pin holes:	pass [<input checked="" type="checkbox"/>] fail []
Porosity (surface):	pass [<input checked="" type="checkbox"/>] fail []
Coloration:	pass [<input checked="" type="checkbox"/>] fail []
Burn through:	pass [<input checked="" type="checkbox"/>] fail []

Qualifier: 337

Date of Test Coupon: 14-06-30

Welder: Barclay Elliott

Date of Test Coupon: 14-06-30

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.

Work Order ID 111307

January-10-14 11:42:15 AM

111307

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 1/10/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-01-10 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100 0.00

100

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MLJ 14-03-04

DP 14-1-30